

Date: Monday, 1/8/2007 10:50:53 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR BODY
Job Number : 30153	
Estimate Number : 11975	
P.O. Number : N/A	Part Number : D2094
This Issue : 1/8/2007	Drawing Number : D2094 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : NA	Drawing Revision : A
Previous Run : 28133	Material : N/A
Written By : _____	Due Date : 2/5/2007
Checked & Approved By : _____	Qty : 50
Comment : Est. B 99.01.20 Re-format DM	Um : Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2061	Aspirator
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Aspirator

Pick:

Qty	Part number	Description	Batch
1	D2061	Aspirator Body	B30161

FF 07-01-28 50

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Drill 4 flange holes as per Dwg D2092/93/94 using Drill Jig DT 8262

FF 07-02-01 50

Cut edges as per Dwg D2095 using Jig DT 8263.

FF 07-02-01 50

Drill 5/16 hole for jet as per Dwg D2092/93/94 using Drill Jig DT 8296

FF 07-02-02 50

Deburr

FF 07-02-05 50

Clean and polish with water and thinner

FF 07-02-05 50

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SB 07/02/05 (50)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 07/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR BODY

Job Number: 30153

Part Number: D2094

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/02/05

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/06

Job Completion



U 07-02-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

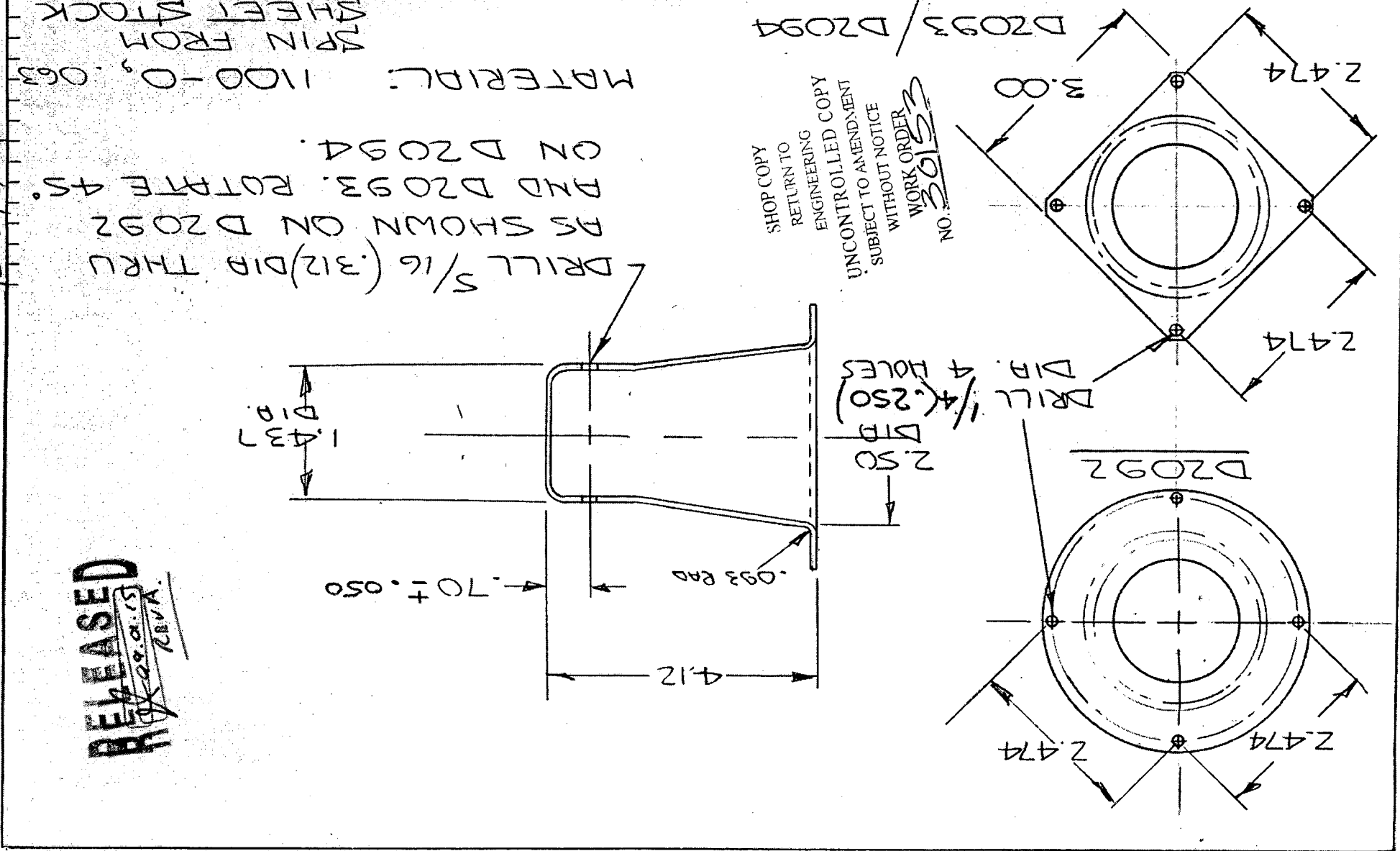
REVISION	APPROVED	DESCRIPTION	CHANGE
A	9/15/70	1/4 HOLE WITH 1/16 DIA. HOLE	1/4 HOLE WITH 1/16 DIA. HOLE
REVISION	APPROVED	DESCRIPTION	CHANGE
A	9/15/70	1/4 HOLE WITH 1/16 DIA. HOLE	1/4 HOLE WITH 1/16 DIA. HOLE

REPORT ALL DISCREPANCIES - DO NOT SCALE	1. DIMENSIONS ARE IN INCHES 2. REMOVE SHARP EDGES .015 MAX 3. SURFACE FINISHES 4. HOLE PER AND 10247 5. HOLE PER AND 10247
REQUIREMENTS - UNLESS OTHERWISE SPECIFIED	1. DIMENSIONS ARE IN INCHES 2. REMOVE SHARP EDGES .015 MAX 3. SURFACE FINISHES 4. HOLE PER AND 10247 5. HOLE PER AND 10247

CLIENT	CHARGE	STRESS	DATE
			1992

CODE	SCALE	SHIFT	DATE
	1:2		10/27/93

REV	DATE	BY
A	10/27/93	



RELEASED
10/29/93
RVA